

**DART**

DESIGN DS	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. E SHEET 1 OF 7
DATE 06.06.09		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	

**RELEASED**06.07.04 *[Signature]***UNDER REVIEW**

06.07.18 CB



dwg update

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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**DART**

DESIGN DS	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3140	REV. E SHEET 2 OF 7
DATE 06.06.09		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM


2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**06-07-04 **UNDER REVIEW**

06-07-18 CB

Ing update

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

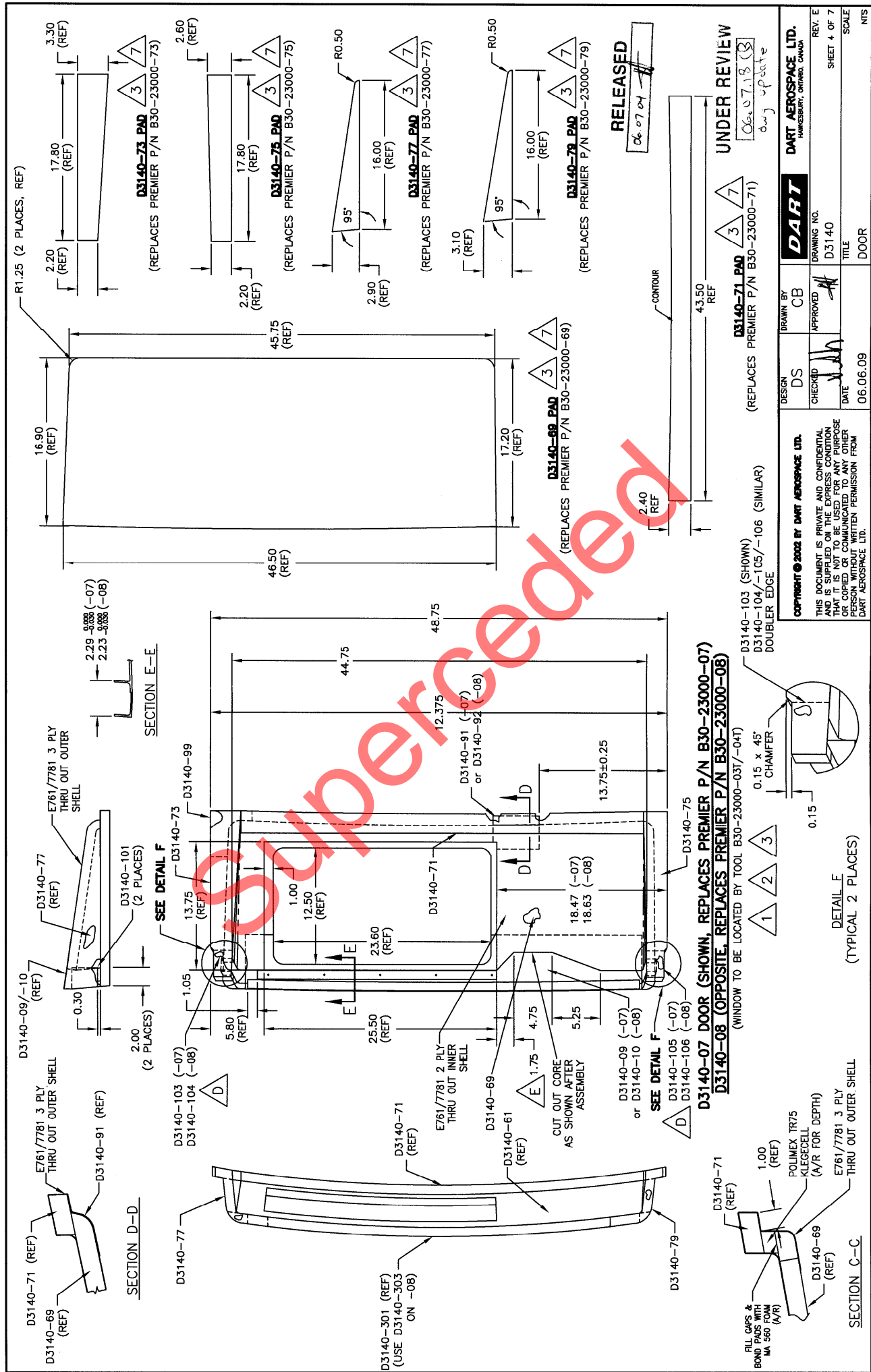
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RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

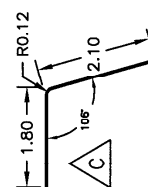
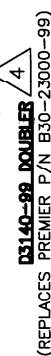
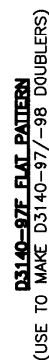
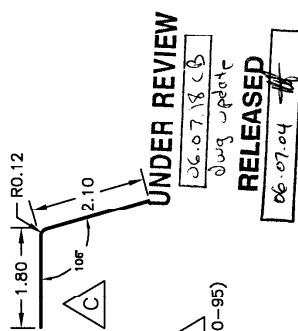
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DESIGN	CHECKED	APPROVED	DRAWN BY
DS	DS	CB	CB
DATE 06.06.09			
TITLE DOOR			
NTS			
DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA			
REV. E SHEET 4 OF 7 SCALE			

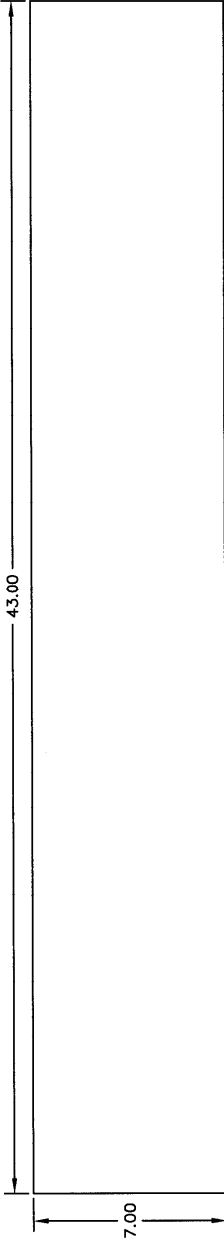


## BEND DETAIL

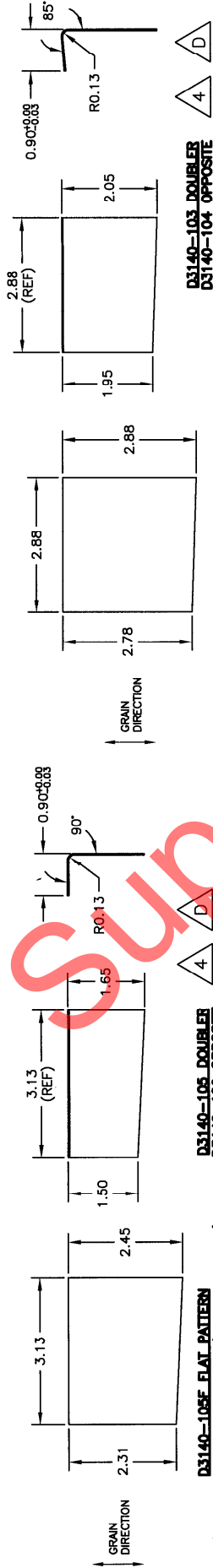


**03140-97 DOUBLER**   
(SHOWN, REPLACES PREMIER P/N B30-23000-97)

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CHECKED 	APPROVED 	DRAWING NO. D3140	REV. E SHEET 5 OF 7			
DATE 06.06.09	TITLE DOOR		SCALE DOOR			
		NTS				

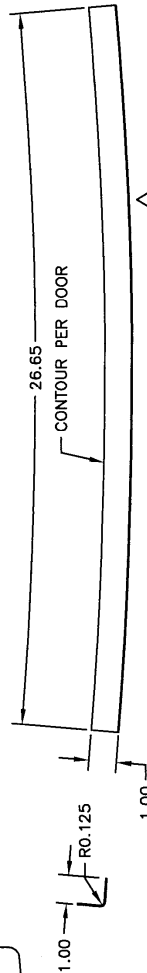
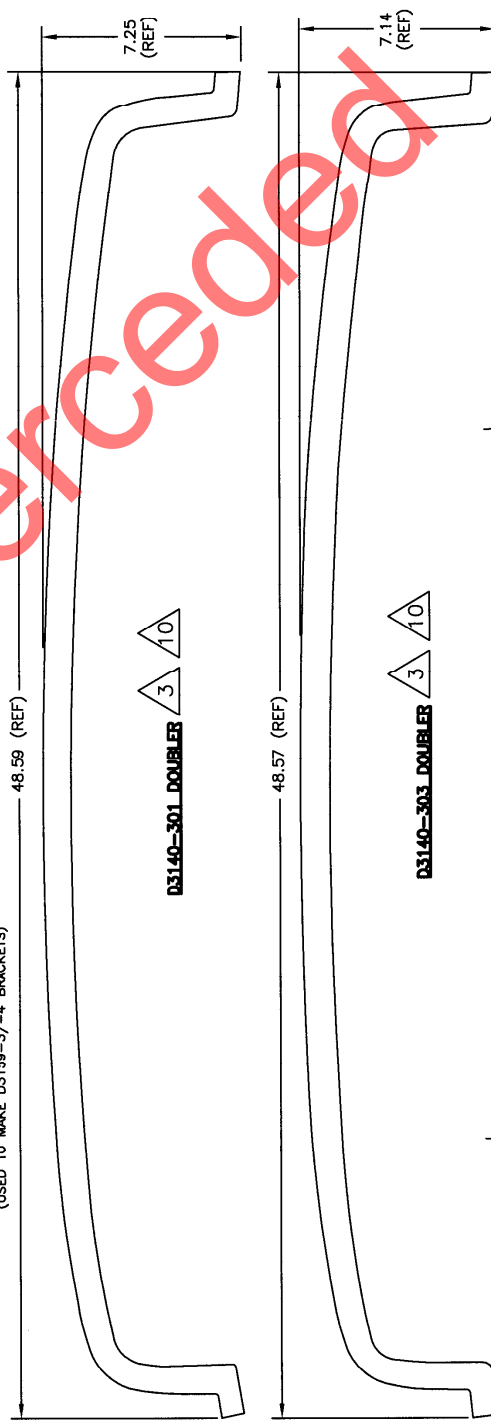


**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)

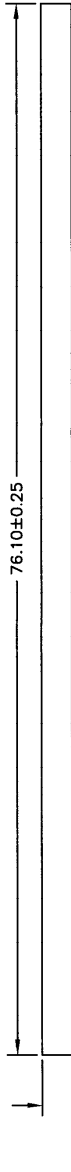


**RELEASED**  
06.07.04

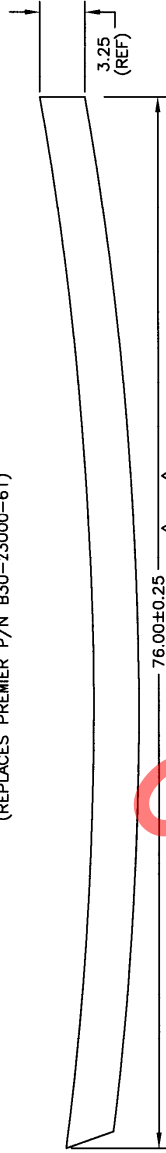
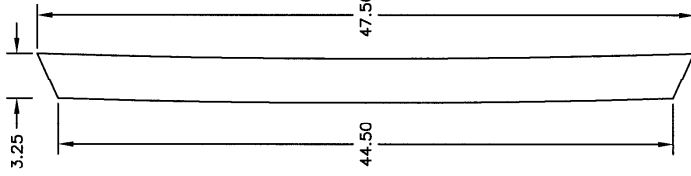
**UNDER REVIEW**  
06.07.18 CB  
dwy update



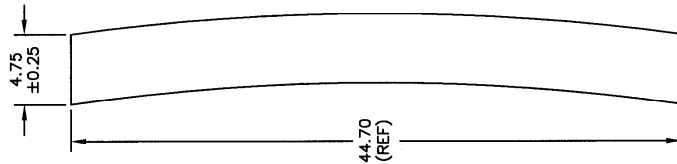
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DATE 06.06.09	APPROVED [Signature]	DRAWING NO. D3140	SHEET 5 OF 7
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**D3140-61 PAD**  
(REPLACES PREMIER P/N B30-23000-61)



**D3140-63 PAD**  
(REPLACES PREMIER P/N B30-23000-63)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)



**D3140-241 DOUBLER**  
(REPLACES PREMIER P/N B30-23000-241)

RELEASED  
06.07.04

UNDER REVIEW

06.07.13 CSB  
dug update

**D3140-58 PAD**  
(REPLACES PREMIER P/N B30-23000-59)

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DATE 06.06.09	TITLE DOOR			